

Date: Thursday, 01/05/2008 9:45:56 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)
<b>Job Number</b>	: 38922		
<b>Estimate Number</b>	: 10533		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D2573
<b>This Issue</b>	: 01/05/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2573 REV E
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 38657	<b>Drawing Revision</b>	: E
	<b>Type</b> : MACHINED PARTS	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 10/05/2008
<b>Checked &amp; Approved By</b>	: <u>JLO 08/05/01</u>	<b>Qty:</b>	8 Um: Each
<b>Comment</b>	: Est: I As Per RevE 06-01-27 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101007	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2573

Ensure that grain is along 7.75" length

Batch No: B 34875

DJP 08/05/16

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Program Batch No. 2.8 Double check by: SA

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

DJP 08/05/20 SA 08/05/17

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

DJP 08/05/20 SA 08/05/17

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

DJP 08/05/20 SA 08/05/17

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 01/05/2008 9:45:56 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 38922

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 08/05/23

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BL 08-05-26

(8)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:50  
320  
12:20

M-1 08/05/26

(8X)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-05-26

(8)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

08/05/22 (8)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/27

Job Completion



MF 08-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 38922
<b>Description:</b> Saddle, Aft Outboard		<b>Part Number:</b> D2573
<b>Inspection Dwg:</b> D2573 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.443	0.443	0.443	0.443		
B	1.745	1.755		1.749	1.747	1.749	1.752		
C	3.495	3.505		3.498	3.500	3.500	3.499		
D	1.745	1.755		1.749	1.748	1.749	1.749		
E	7.990	8.010		7.995	7.997	7.997	7.997		
F	0.490	0.510		.504	0.496	0.506	0.507		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.498	.498	.500	.500		
J	1.174	1.184		1.181	1.181	1.181	1.180		
K	0.558	0.578		.565	.570	.570	.570		
L	1.174	1.184		1.181	1.181	1.181	1.180		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.499	2.500	2.500	2.501		
O	4.119	4.129		4.121	4.121	4.121	4.121		
P	0.115	0.135		.122	.122	.117	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.256	.256	.247	.248		
S	0.115	0.135		.130	.122	.124	.124		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.250	.244	.240	.240		
W	0.115	0.135		.132	.130	.122	.122		
X	0.308	0.313		0.308	0.311	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		.353	0.3548	0.364	0.364		
AA	0.470	0.530		.500	.520	.500	.500		
AB	0.615	0.635		.620	0.6305	0.633	0.634		
AC	0.053	0.073		.063	0.063	0.063	0.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.511	1.511	1.510	1.520		
AF	0.115	0.135		.119	.120	.135	.135		
AG	0.240	0.280		.256	.260	.260	.260		
AH	0.240	0.260		.257	.250	.253	.253		
AI	2.000	2.020		2.001	2.001	2.001	2.009		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: <i>SP</i>
Date: 08/05/17

Audited by: <i>SD</i>
Date: 08/05/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 38922
<b>Description:</b> Saddle, Aft Outboard		<b>Part Number:</b> D2573
<b>Inspection Dwg:</b> D2573 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

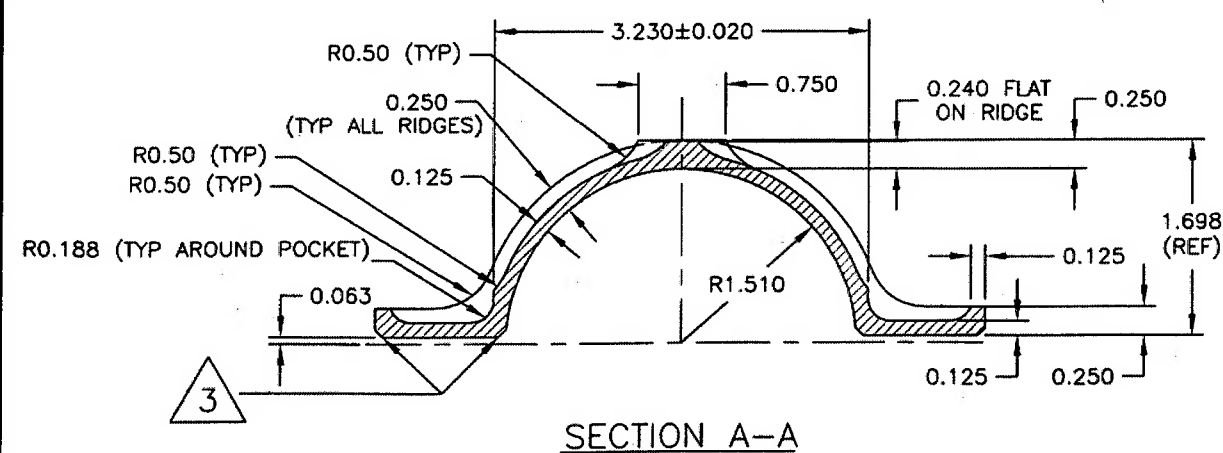
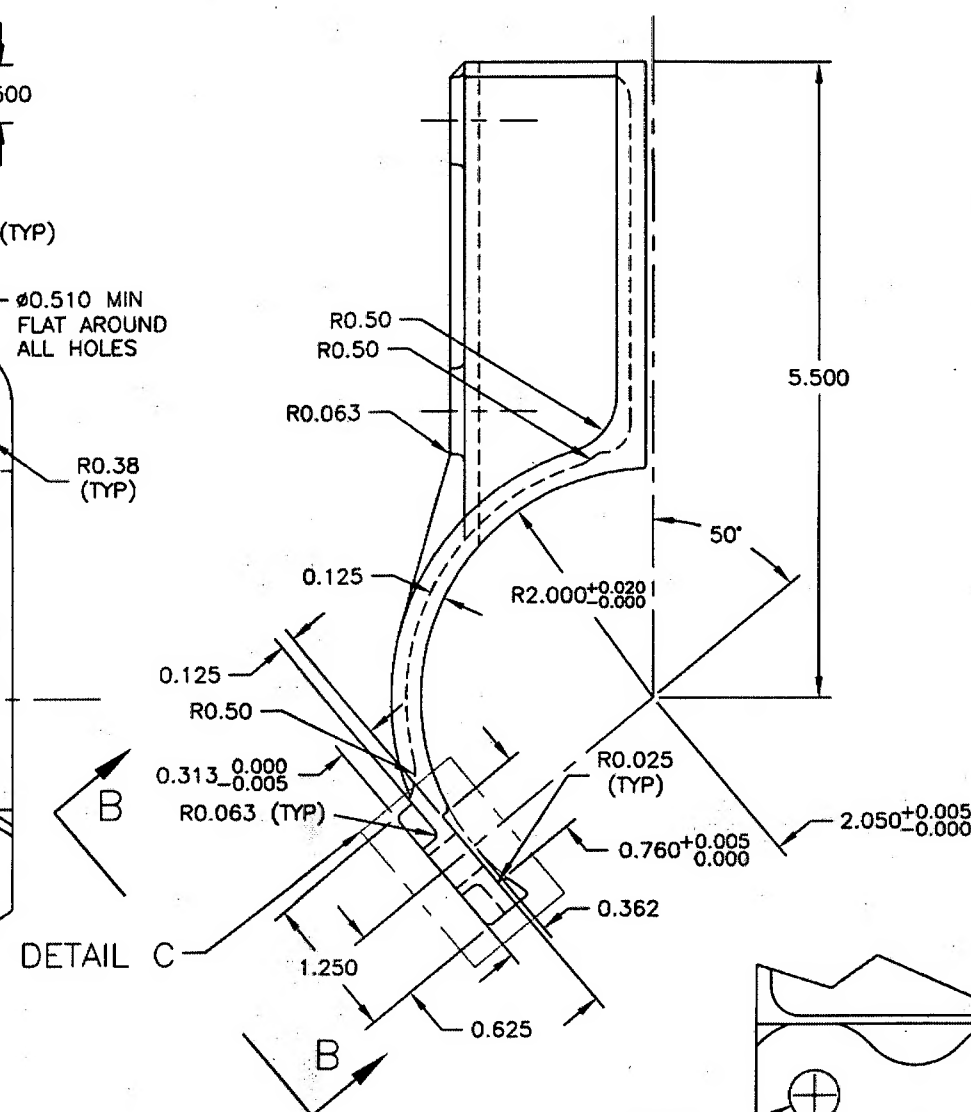
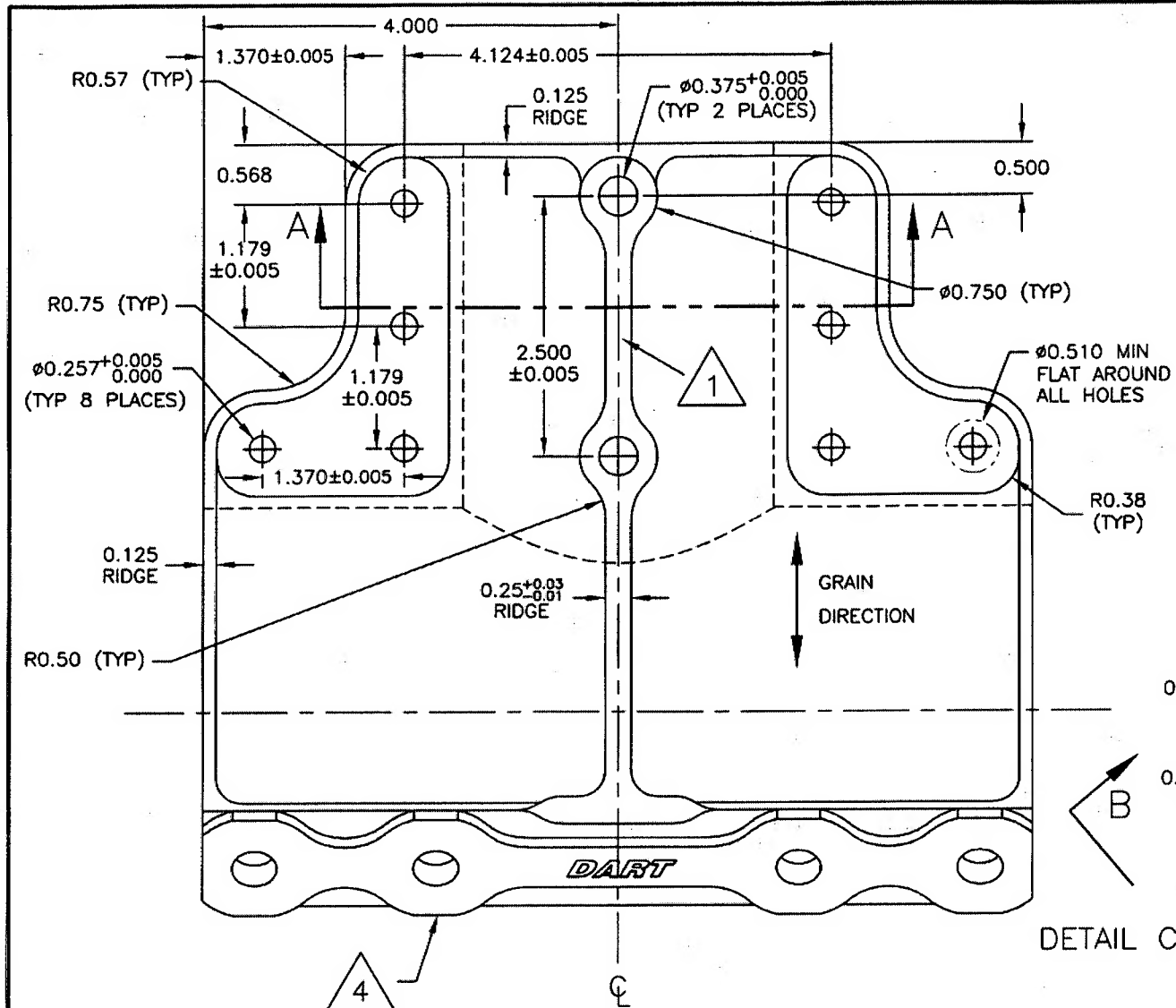
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	0.438	0.443		0.443	.443	.443	.443		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.998	7.998	7.996		
F	0.490	0.510		0.508	.500	.50	.500		
G	0.257	0.262		.253	.258	0.258	0.258		
H	0.375	0.380		.377	.377	0.378	0.3785		
I	0.490	0.510		0.499	0.4985	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.180		
K	0.558	0.578		0.562	0.563	0.566	0.563		
L	1.174	1.184		1.179	1.179	1.180	1.180		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.121	4.121	4.120	4.121		
P	0.115	0.135		.124	.125	0.122	0.123		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		.249	.250	0.250	0.248		
S	0.115	0.135		0.115	0.120	0.122	0.120		
T	0.178	0.198		.188	.188	0.188	0.188		
U	3.210	3.250		3.230	3.231	3.230	3.230		
V	0.230	0.250		0.230	0.235	0.235	0.232		
W	0.115	0.135		0.119	0.123	0.123	0.122		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		0.363	.362	.362	.365		
AA	0.470	0.530		.500	.500	0.500	0.500		
AB	0.615	0.635		0.629	.629	.625	.625		
AC	0.053	0.073		0.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	0.248	.250		
AE	1.500	1.520		1.520	1.513	1.5125	1.5135		
AF	0.115	0.135		0.120	0.130	0.130	0.122		
AG	0.240	0.280		.260	.260	0.260	0.260		
AH	0.240	0.260		0.240	0.245	0.2455	0.244		
AI	2.000	2.020		2.009	2.003	2.0025	2.0035		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: *[Signature]*  
Date: 08/09/18 / 08/05/20

Audited by: *[Signature]*  
Date: 08/10/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

05.12.06

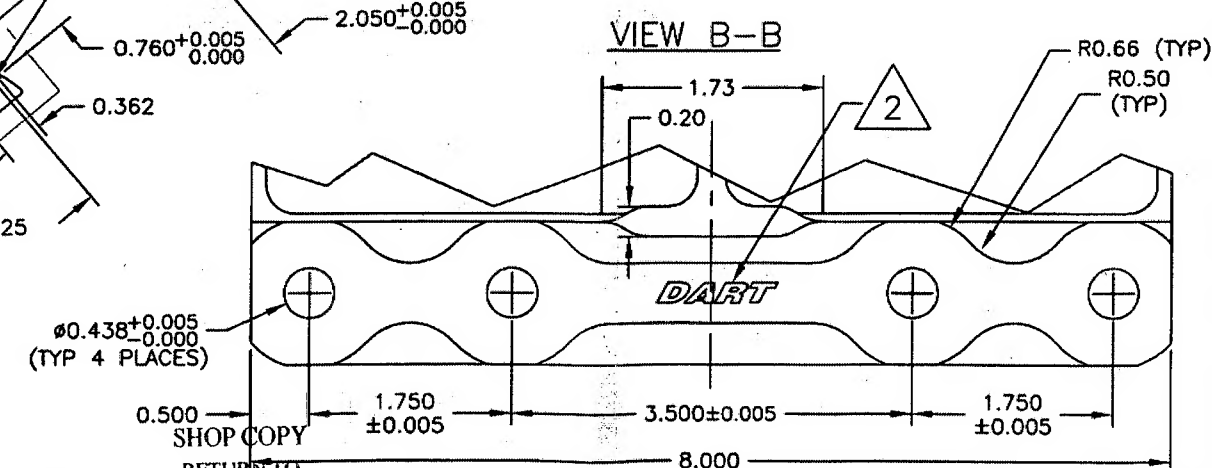


DETAIL C  
SCALE 4:3




## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES: ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)



5 UNCONTROLLED COPY  
(TYP) SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
R0.025 38922  
(REF TYP)

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
CHECKED 		APPROVED 
DATE 05.07.13		TITLE OUTER AFT SADDLE
		 <b>DART AEROSPACE LTD.</b> HAWKESBURY, ONTARIO, CANADA
		DRAWING NO. D2573 REV. E SHEET 1 OF 1 SCALE 2:3

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